

Blue

Work Order ID 55799

February 1, 2010 12:43:35 PM



Item ID: D2724-041

Accept



Setup Start



Revision ID:

Stop



Item Name: 206L Step Assembly

Start Date: 2/02/10 Start Qty: 4.00



Cust Item ID:

Required Date: 2/19/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2724

Rev C

100

0.00



Large Fab

Large Fab

Memo

0.00

Cut D2724-1 using D2622 extrusion as per Dwg D2724
Deburr and bevel ends for welding

10.02.09 *PE*

4 ϕ

110

0.00



Large Fab

Large Fab

Memo

0.00

Weld end cap and lugs as per Dwg D2724 using Jig DT8884 followed by
Jig
DT (One End Only)
A/R AL ROD Batch: m110130
Grind end cap welds flush m111311

PE 10.02.09

4 ϕ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

DB 10.02.09 (4)

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/2010

(x4)

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10-02-10

4

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 2/19/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

⇒ m-d 10/02/10

4X

160

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

Inspect for foreign object per QSI 024
Weld Remainig end cap as per Dwg D2724 using Jig DT8884 followed by Jig
DT
A/R AL ROD Batch: M110130
Grind per dwg D2724

10.02.11

4

170

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control



PD 10.02.11 (4)




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Item ID:	D2724-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	206L Step Assembly					
Start Date:	2/02/10	Start Qty:	4.00		Cust Item ID:	
Required Date:	2/19/10	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	S. 02/02/10			(24/27)			
190  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	BR 10-02-17.			(4 LH)			
205  SprayPaint Spray Painting	prime grey per QSI005 B 1109/8 Paint Delfleet Blue B 113171 Clear Delfleet B 113314	0.00 0.00	10 02 22			(4)			

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Item Name: 206L Step Assembly

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Cust Item ID:

Required Date: 2/19/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

206

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

IT 10-02-22 (4)

220

Wing Walk as per dwg QSI005 4.4 Batch 113462 0.00



HandFinish

Memo

0.00

Hand Finishing

BR 10-02-24 (4) LH

230

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

ES 10/02/2011 (4) W7

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Required Date: 2/19/10 Req'd Qty: 4.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

240

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PM 55799

0.00

Packaging

Per 10/3/03 (4)

250

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/03

MF 10-3-1

Picklist Print

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Page 1

Work Order ID: 55799

Parent Item: D2724-041

Parent Item Name: 206L Step Assembly



Comments: IPP Rev:E As Per Ecn 766 06-01-06 JLM

Start Date: 2/02/10

Required Date: 2/19/10

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2622-120C  Step Extrusion		Manufactured	No			110	Each	48.7400	4.0000 		<i>Ph 10.02.09</i>	

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA 48.74

48612 3.12

52026 45.62

D2734 Manufactured No 110 Each 79.0000 8.0000



Step End Plate



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 9

43535 2

48110 7

Main Warehouse

WA 70

55014 70

4+4

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 55799

Parent Item: D2724-041

Parent Item Name: 206L Step Assembly

Start Date: 2/02/10

Required Date: 2/19/10

Comments: IPP Rev:E As Per Ecn 766 06-01-06 JLM

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3458-1		Manufactured	No			110	Each	51.0000	8.0000			



Step Mounting Plate

Ph 10.02.09

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

51

51239

3

53408

48

8

D3458-3		Manufactured	No			100	Each	45.0000	8.0000			
---------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--



Step Mounting Plate

Ph 10.02.09

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

45

53409

45

8

February 1, 2010 12:43:33 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

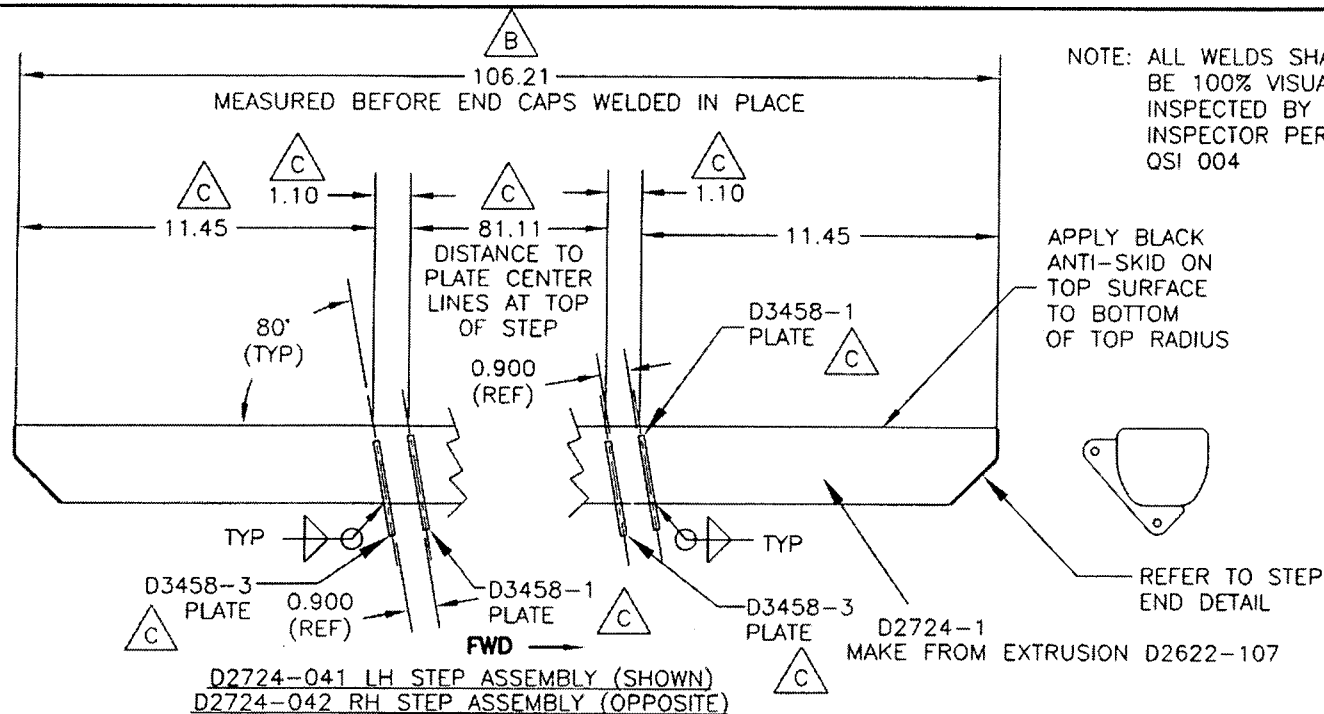
NOTE: Date & initial all entries

DART

RELEASED

05.11.14

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004



D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	PORT HADLOCK, WA
DATE	05.09.19	TITLE	206L/407 STEP ASSEMBLY	REV. C	SHEET 1 OF 1
				SCALE	NTS
	A	97.12.04	NEW ISSUE		
	B	98.10.19	UPDATED WELD DETAIL REVISED TOLERANCES		
	C	05.09.19	RE-DESIGN, ADD D3458-1/-3		